

Work Order ID 54712 - 1

*Split*



Page 1

December 16, 2009 3:28:43 PM

Item ID: D2492

Accept



Setup Start



Revision ID:

Stop



Item Name: Patient Stop

Start Date: 16/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *HL*

Date: *12-16*

Tooling:

Date:

Run Start



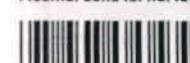
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2492

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2492  
Deburr if necessary

Dwg Rev: *F*

Prog Rev: *F*

2-

*6061 . 080*

*B 10-1-6*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*B 10-1-6*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*77 S106107*

*(710)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54712**

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Required Date: 21/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

SAD

8

Brake NC

Deburr Form using Jig DT2492B

10-01-2  
10-02-01

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

=&gt; Siobelo

x8

Quality Control

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

BR 10-02-01

8.8

Hand Finishing

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 54712

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Start Date: 16/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10/02/02

18

0

Quality Control

170

White Gloss(Ref.4.3.5.1) per QS1005.4.3-Alum

0.00



Powdercoat

Memo

0.00

10/02/02

18

0

Powder Coating

START TIME:

10:00AM

OVEN TEMPERATURE:

10:30AM FINISH TIME:

320°C

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

10-02-02

18

0

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54712**

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Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg & Stock Location: 220

0.00



Packaging

Memo

0.00

Packaging

*10/2/03* *(S)*

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/02/03* *(S)*

*MF 10-2-3*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

December 16, 2009 3:28:47 PM

Page 1

Work Order ID: 54712



Parent Item: D2492



Parent Item Name: Patient Stop

Start Date: 16/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

370.3809

11.5131

20.



B 10-1-6

6061-T6 .080 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

370.38087

110630

33.5136

112141

0.86727

113438

336

113438

10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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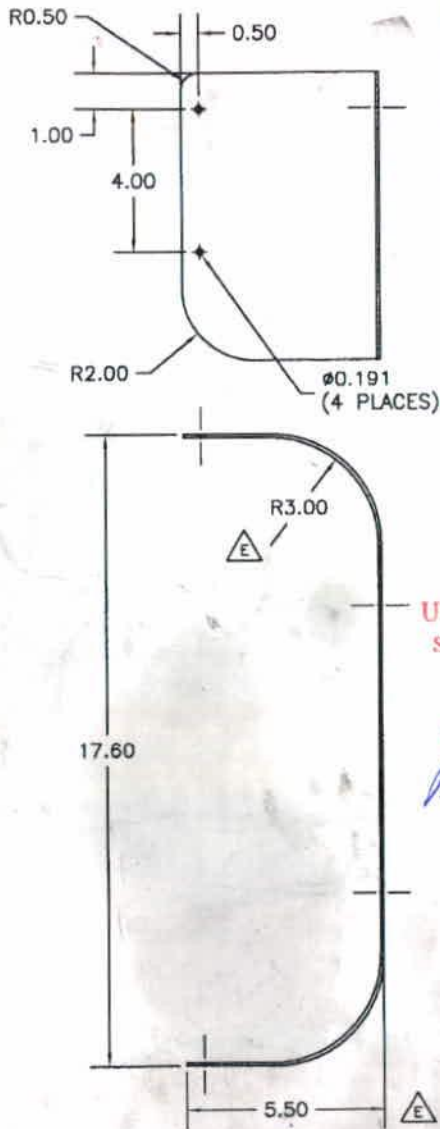
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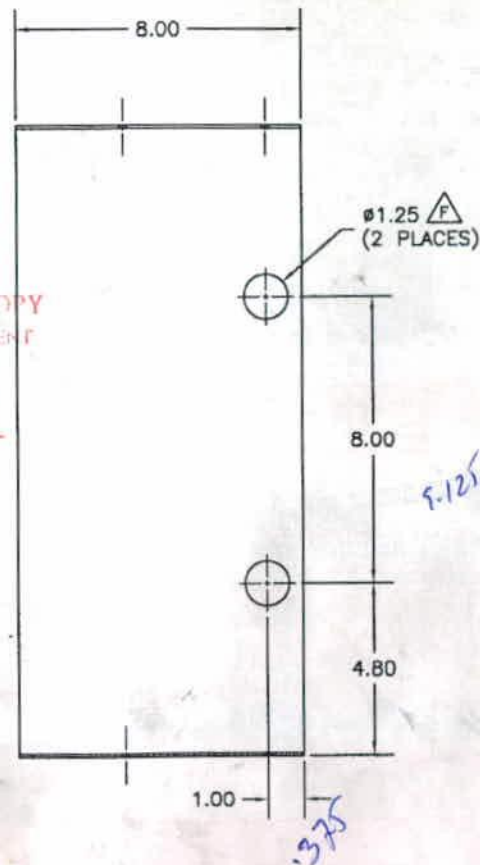


**DART**

DESIGN KE	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2492	REV. F SHEET 1 OF 1
DATE 06.09.14	TITLE PATIENT STOP		SCALE 1:5
A	95.10.24	NEW ISSUE	
B	96.02.28	MINOR CHANGES	
C	97.07.14	CHANGED MATERIAL AND FINISH	
D	98.05.11	R4.00 WAS R2.00 ADDED 8" WIDTH DIMENSION	
E	06.05.30	ADD 6061-T6 MATERIAL, R3.0 WAS R4.00, 5.50 WAS 6.00	
F	06.09.14	Ø1.25 WAS Ø1.020	



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54712  
*PH 09-12-16*

**D2492 PATIENT STOP**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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